LANL Engineering Standards Manual OST220-03-01-ESM   **Chapter 13, Welding**

WPS 3-01 – Application of Welding Procedure Specifications   Rev. 0, 8/16/04
Attachment 5: API Welding Procedure Specification Form   Page 1 of 2

API WELDING PROCEDURE SPECIFICATION

WPS: _____   REV. NO.: _____   PROCESS: _____   DATE: _____

API-1104 QUALIFIED PRANGES

Diameter: _____   Filler Metal Group: _____

Thickness: _____   Joint Type: _____

Material: _____

Position's: Fixed: ☐   Rolled: ☐   Progression: _____

NOTE: This WPS shall be used in conjunction with the applicable sections of the LANL General Welding Standard (GWS).

WELD JOINT: Type: _____   Class: _____

Joint Description: _____

Sketch Number: _____

FILLER MATERIALS: API Group No.: _____   AWS Class: _____

SFA Class: _____   F No.: _____   Sizes (s): _____

Number of Beads: _____

BASE MATERIALS: Spec: _____   to   Spec: _____

Thickness Welded: _____   to   _____

Pipe Diameter: _____   to   Pipe Diameter _____

ASME   P No.: _____   Group: _____   to   P No.: _____   Group: _____

POSITIONS: Fixed: ☐   Rolled: ☐   PWHT: Time at ºF.: _____

Progression: _____   Temperature Range ºF: _____

PREHEAT: Minimum Temp º F: _____   GAS: Shielding: _____   Backing: _____

Composition: _____

Flow Rate: _____ CFH

ELECTRICAL CHARACTERISTICS: _____

Current: _____   Polarity: _____   RANGES   Amps: _____

Transfer Mode: _____   WFS/IPM: _____   Volts: _____

Electrode size and Type _____   Travel/IPM _____

MAX. TIME BETWEEN PASSES: _____

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WPS No.: _____   Rev. No.: _____   Date: _____

WELDING TECHNIQUE

Line-Up Clamp: _____

Stringer (S) or Weave (W) Bead: _____   Single Pass _____   Multi Pass _____

Cleaning and/or Grinding: _____

PROCEDURE QUALIFIED FOR: Charpy V Notch ☐   NDTT ☐   D.T. ☐

Maximum K/J Heat Input: _____

JOINT SKETCH AND BEAD NUMBER AND SEQUENCE

NOTE: Weld layers are representative only — actual number of passes and layer sequence may vary due to variation in joint design, thickness and fit-up.

TYPICAL WELDING PARAMETERS

Pass Number	Filler/ Electrode	Size	AMPS	VOLTS	Travel Speed	Other
1						
2						
3						
4						
5						
6						
7						
8						

PREPARED BY: _____   DATE: _____

APPROVED BY: _____   DATE: _____